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ARC

D350-591-312
Job Sheet 198852



Part No: D350-591-312

Job Qty: 10 pcs ✓

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 9/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	9/10/19	9/10/19	0.00	10.00	Large Fab - 1		SLU
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	9/10/19	9/10/19	0.00	0.00	QC 9 - 10		SEP 05 2019
							QC 9 - 18	DAS 24	
							QC 9 - 24	9-89	
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	9/10/19	9/10/19	0.00	0.00	QC 5 - 10		SEP 05 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS 24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	9/10/19	0.00	1.87	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	SEP 05 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	9/10/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	SEP 05 2019
						QC 7 - 30	
						QC 7 - 34	DAS 24 8-89
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
180	Large Fab - Steps - 2 - B4B	10	9/10/19	0.00	10.00	Large Fab - 1 - B4B	

	pcs					Large Fab - 10 - B4B		
						Large Fab - 2 - B4B		
						Large Fab - 3 - B4B		
						Large Fab - 4 - B4B		
						Large Fab - 5 - B4B		
						Large Fab - 6 - B4B		
						Large Fab - 7 - B4B		
						Large Fab - 8 - B4B		
						Large Fab - 9 - B4B		
						Large Fab - 11 - B4B (Various)		
190 QC 10	10 pcs	9/10/19	0.00	0.00		QC 10 - 10		
						QC 10 - 18		
						QC 10 - 24		
						QC 10 - 43		
						QC 10 - 50		
						QC 10 - 58		
						QC 10 - 9		
200 QC 5	10 pcs	9/10/19	0.00	0.00		QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		
210 Handfinish - 1-2- Chemical- B4B	10 pcs	9/10/19	0.00	1.87		Handfinish - 1 - 1 - B4B		
						Handfinish - 1 - 2 - B4B		
						Handfinish - 1 - 3 - B4B		
						Handfinish - 1 - 4 - B4B		
						Handfinish - 1 - 5 - B4B		
						Handfinish - 1 - 6 - B4B		
						Handfinish - 1 - 7 - B4B		
						Handfinish - 1 - 8 - B4B		
						Handfinish - 1 - 9 - B4B		
						Handfinish - 1 - 10 - B4B		
						Handfinish - 1 - 11 - B4B		
						Handfinish - 1 - 12 - B4B		
						Handfinish - 1 - 13 - B4B		
						Handfinish - 1 - 14 - B4B		
						Handfinish - 1 - 15 - B4B		
						Handfinish - 1 - 16 - B4B		
						Handfinish - 1 - 17 - B4B		
						Handfinish - 1 - 18 - B4B		
						Handfinish - 1 - 19 - B4B		
						Handfinish - 1 - 20 - B4B		
						Handfinish - 1 - 21 - B4B		
						Handfinish - 1 - 22 - B4B		

220	Powdercoat - 1 White Gl(A)- B4B	10 pcs	9/10/19	0.00	2.98	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk- B4B	10 pcs	9/10/19	0.00	1.87	Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	BEB 19-09-11
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
240	QC 3	10 pcs	9/10/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250	Packaging 1-1 - Pick Kit - B4B	10 ✓ pcs	9/10/19	0.00	0.00	Packaging 1 - 1 - B4B ✓	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	

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260 QC 4	10 pcs	9/10/19	0.00 0.00	Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
270 Packaging 3-1 - Stock - B4B	10 pcs	9/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	9/10/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	10 pcs	9/10/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Closed wo only

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI
 Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 2:35 OVEN TEMPERATURE 320°

FINISH TIME: 3:05 11/13/19 5:20 362.

230 - Wing Walk as per dwg QSI005 4.4 Batch

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S198236 ✓
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	S199742 ✓
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	S209859 ✓
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	S202452/S207083 ✓
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	S198132 ✓
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	S207585 ✓
AN3-35A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S185557 ✓
AN4-13A	Bolt	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S146190 ✓
AN5-36A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S173839 ✓
D2230-3	Mounting Lug	40 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S199078 ✓
D2618	Bushing	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S172242 ✓
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S1228207/S212989 (10) ✓
D3235-1	Mounting Lug	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S187347 ✓
D3278-041	Support Assembly	10 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S206074 ✓
MS21042L3	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S204283 ✓
MS21042L4	Nut	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S241536 ✓
MS21042L5	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S208332 ✓
NAS1149D0363J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S201031 ✓
NAS1149D0463J	Washer	160 Ea (16 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S206989 ✓
NAS1149D0563J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S174288 ✓

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	203	0
	D3219-1	20	95	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	23	0
	D3066-1	20	257	0
	MS20600-AD4W4	160	1,408	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	324	0
	AN4-13A	80	1,260	0
	AN5-36A	20	219	0
	D2230-3	40	648	0
	D2618	20	208	0
	D2856-400-720	20	24	0
	D3235-1	20	287	0
	D3278-041	10	10	0
	MS21042L3	20	685	0
	MS21042L4	80	3,035	0
	MS21042L5	20	387	0
	NAS1149D0363J	40	1,694	0
	NAS1149D0463J	160	4,174	0
	NAS1149D0563J	40	2,029	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS					
		Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐				
		Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐				
		Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐				
					Quality ☐				
Date: _____		Sequence #: _____		QTY Affected: _____					
Description Work Order Deviation		Disposition		MRB (QS1042)					
				Completed By					
				Lead hand / Supervisor					
				QC / QA Coordinator					
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details: _____							

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4		D2230-3	MOUNTING LUG
2	2	2	2	2		D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2		D2856-400-720	ABRASION STRIP
2	2	2	2	2		D3235-1	MOUNTING LUG
				1		D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2		AN3-35A	BOLT
				8		AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2		AN5-36A	BOLT
4	4	4	4	4		NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16		NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4		NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2		MS21042L3	NUT
6	6	6	6	8		MS21042L4	NUT
2	2	2	2	2		MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.